



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T102103
Job Sheet 170101



001057

Part No: RB T102103

Job Qty: 6 ea

Part Name: Dehydrator Tail Rotor



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev A 17.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/18/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	6 pcs		1/19/18	0.00	2.00	Small Fab-3		MCC DAS
120	QC	6 pcs		1/19/18	0.00	0.00	QC5		38
130	Packaging	6 pcs		1/19/18	0.00	0.00	Packaging3-1		FEB 23 2018
140	QC21-FG	6 Ea		1/19/18	0.00	0.00	QC21		FEB 26 2018

Part Op 110 - Assemble as per DWG. Sheet 1

Descriptions:

DAS FEB 21 2018

DAS FEB 21 2018

DAS FEB 21 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	252 MS27215-2	6	1	0	0
	MS29561-210	6	124	0	0
	RB T102103-3	6	2	0	0
	RB T102103-5	6	2	0	0
	RB T102103-7	6	2	0	0

Part Specifications

Specifications could not be found.



Container No: S044055



Part: RB T102103

Job No: 170101

Serial No/Batch: S044055

Revision: RB T102103

Inspector:

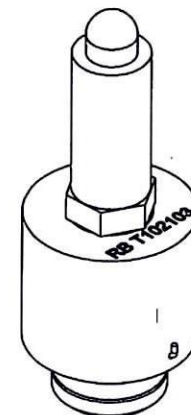
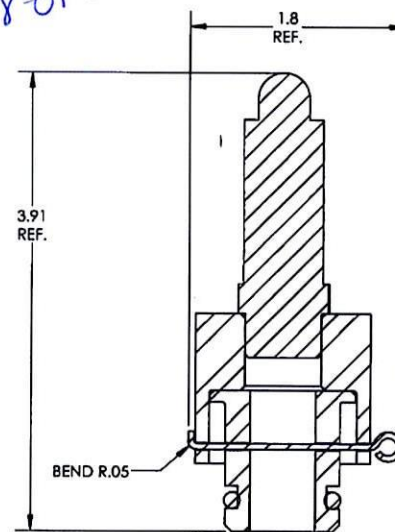
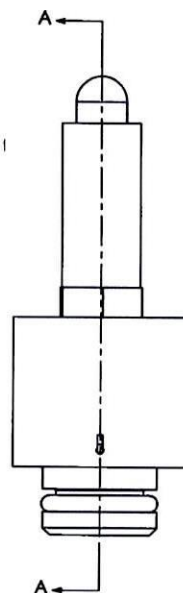
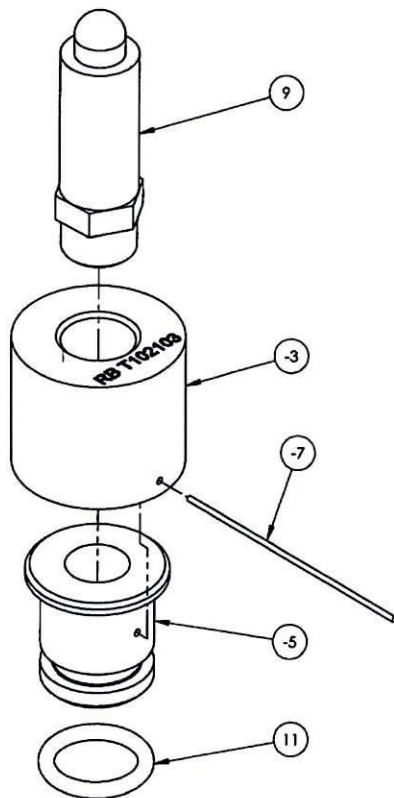
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/21/18

ITEM #	QTY	PART #	TITLE	PG
-3	1	RB T102103-3	ADAPTER	2
-5	1	RB T102103-5	RETAINER	3
-7	1	RB T102103-7	PIN .050" OD. x 2-1/2" LG.	4
8	1	MS27215-2	PLUG DEHYDRATOR	-
11	1	MS29561-210	O-RING 1.012" OD x 0.135" THK	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-	REDRAWN FROM TATTERED ORIGINAL DRAWING	-	11/1/2012	RJC	SE
A	-3 CHD NOTE WAS FINE DIAMOND OR STRAIGHT KNURL THIS SURFACE IS MEDIUM DIAMOND OR STRAIGHT KNURL THIS SURFACE	-	3/11/2014	DPD	GE
1	-3 ADDED BOTH SIDES TO CHAMFER	15-0156	7/1/2015	SM	JAG
C	ADD SHEET 4 FOR -7. TEMPLATE UPDATED. REMOVE GD&T COCENTRICITY TOLERANCE ON -5, REMOVE LIMIT TOLERANCE FOR 0.086" Ø HOLE ON -5, ADD 2 PL. ON RADIUS .015" Ø ON -3 & -5	17-709	17.10.16	VM	WM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170101 1105
18-01-10



- NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) SPEC: N/A
5) BREAK ALL SHARP EDGES: N/A
6) IDENTIFICATION: N/A

RB T102103 DEHYDRATOR TAIL ROTOR

DART AEROSPACE Huntsbury, Ontario, Canada			
TITLE: DEHYDRATOR TAIL ROTOR			
PART NO.: RB T102103			
DESIGN BY: VM 10/16/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
DRAWN BY: VM 10/26/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
CHECKED: SAC 10/27/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
IMP. APPR: DP 10/30/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
APPROVED: WM 10/31/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
DATE: 10/26/2017	CHK: JOK 2/200	FRACTIONS: 2/16	ANGLES: 9.5°
SCALE: NTS	WEIGHT: N/A	SHEET 1 OF 4	
COPYRIGHT © 2017 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					